

| | | | |
|--|----------|--------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 39952 |
| Description: Blade Positioner Weldment | | Part Number: | 367-43001-29 |
| Dwg: 367-43001 | SHEET 40 | Qty: | 5 |
| | | Page of | |

| Step | Location | Procedure | By | Date | Qty |
|------|-----------|---|----|------|-----|
| 1 | DC | Issue Traveler | | | |
| 2 | cut GA WJ | gusset - 319 use mat: 090 6061-T6 al. (m7950), cut 12.00" x 3.00" (mark part out on piece as per drawing), drill hole in center as per drawing. deburr. | | | 2 |
| 3 | cut GA WJ | plate - 313 & 317 use mat: 090 6061 T6 al. (m7950) make as one part 24.5" x 2.5" (mark out parts and bend) deburr | | | 1 |
| 4 | cut GA WJ | plate - 337 use mat: 090 6061 T6 al. (m7950) cut and mark part for bending & (bend as per drawing) deburr | | | 2 |
| 5 | weld WA | all parts together | | | |
| 6 | drill GA | when inside part is made (material and padding) match hole on part 1/4" hole 7 holes in total. | | | |
| 7 | chem. FP | chemical conversion OSI 0054.1 | | | |
| 8 | paint FP | powder coat green sinter OSI 0054.3 | | | |
| 9 | QC3 | Inspect Powder Coat. | | | |
| 10 | SI | Identify & Stock. | | | |
| 11 | DC | Level 21 / Close w/o. | | | |
| 6B | QC19 | Inspect Work / Weld. | | | |
| 1 | | | | | |

PRELIMINARY ISSUE

| Rev | Date | Change | Revised By | Approved |
|-----|------|--------|------------|----------|
| | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

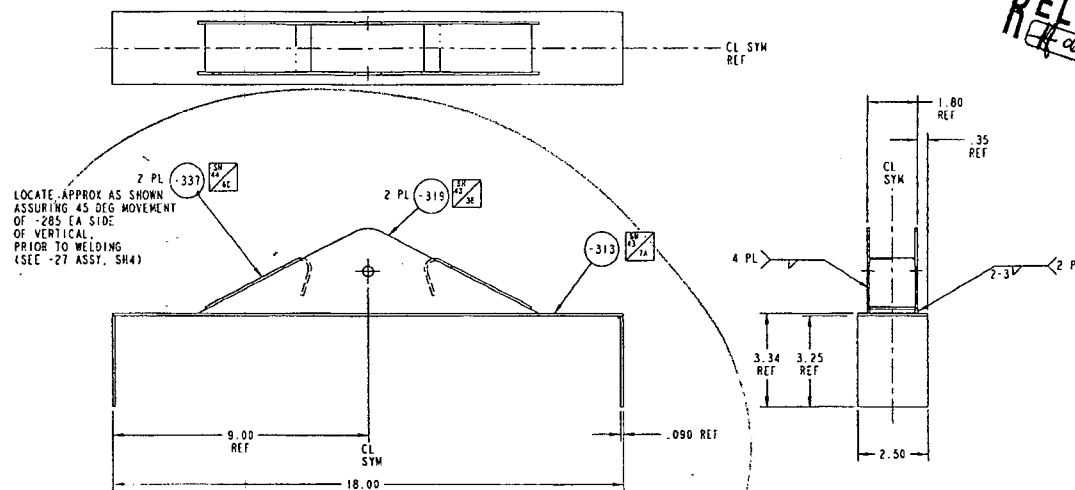
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

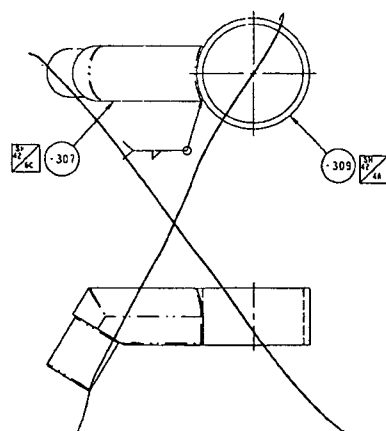
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

RELEASED
06-01-20



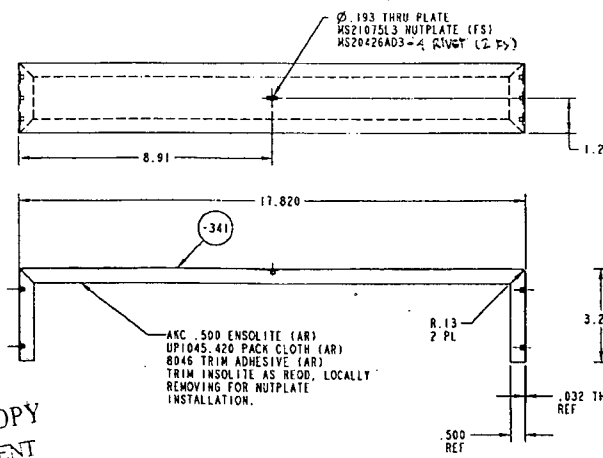
① -29 BLADE POSITIONER WELDMENT
SCALE 0.500



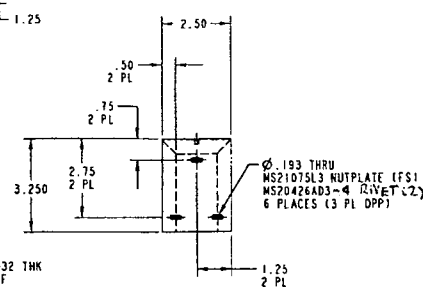
-25 TUBE GUIDE WELDMENT
SCALE 1.000

SUPERSEDED BY
D3440-1 & D3440-3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
40241



① -35 LOWER PAD ASSY
SCALE 0.500
MATL FOR -341: .032 THK 2024-T3, QQ-A-250/4



PREMIER AVIATION, INC.
3001 Aviation Parkway, Grand Prairie, Texas 75052
SHEET: 001 OF 001
D05UV8 B67-43001 B1
SCALE: 1:1 SHEET: 40 OF 45

ORIGINAL

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 8:45:33 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER WELDMENT

Job Number: 40241

Part Number: PB674300129

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/07/21 (X)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2/17/11

08/07/21

(S)

8.0

POWDER COATING

POWDER COATING



M102316



(S)

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40
320 OF
2:10

m-h 08/07/21

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/07/21 (5)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

512

P 8/7/23

(5)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/24

Job Completion



mf 08-07-24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Friday, 7/4/2008 8:45:33 AM
 User: Kim Johnston

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BLADE POSITIONER WELDMENT |
| Job Number : 40241 | |
| Estimate Number : 13443 | |
| P.O. Number : | Part Number : PB674300129 |
| This Issue : 7/4/2008 S.O. No. : | Drawing Number : B6743001 P.40 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : LARGE FAB ASSY | Drawing Revision : B1 |
| Previous Run : | Material : |
| Written By : <u> </u> | Due Date : 7/10/2008 Qty: 5 Um: Each |
| Checked & Approved By : <u> </u> | |
| Comment : Est Rev:A 08-06-27 new issue DD verified by:ec | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------|-------|
| 1.0 | PB6743001313 | Plate |
|-----|--------------|-------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Plate
 batch: 340065

 08-01-18 5

| | | |
|-----|--------------|--------|
| 2.0 | PB6743001319 | Gusset |
|-----|--------------|--------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Gusset
 batch: 340069

 08-01-18 5

| | | |
|-----|--------------|--------------------|
| 3.0 | PB6743001337 | Upper Pad Assembly |
|-----|--------------|--------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Upper Pad Assembly
 batch: 340095

 08-01-18 5

| | | |
|-----|-------------|------------------------------|
| 4.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1
 ****FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG. MOVEMENT OF -285 EACH SIDE OF
 VERTICAL, PRIOR TO WELDING****

1- ASSEMBLE AND WELD AS PER DWG

 08-01-18 5

| | | |
|-----|-----|---------------------------|
| 5.0 | QC9 | VISUAL WELDING INSPECTION |
|-----|-----|---------------------------|



Comment: VISUAL WELDING INSPECTION

 08-01-18 5